Auto Cable Cutting Machine (HK-27K)
User Manual

1. USAGE:

For cutting of patch cord (or similar products), unwind the cable from the wheel, cut it into sections by specified length and quantity, and then wind into circle loop.

2. Characteristic:

- **High Automation**: Auto operation and process from raw cable to final sections, include length measurement, quantity counting, cut, unwind and wind.
- **High Length Accuracy**: Use Meter Wheel to count length, no tolerance from cable twist, slip etc, and achieve high accuracy by revising coefficient according to practical measurement.
- **High Efficiency**: Take 10m as typical, takes less than15 sections.
- **Simple & Easy Operation**: Use single button, control entire running process. Use particular instruments to setup length and quantity, it's obvious and simple; achieve various manual functions by Manual Buttons over control panel.
- **Stable Performance**: Strong mechanical structure from accurate manufacturing, with intellectual instruments, gets stable and reliable performance.
- **Compensation Function**: Easy to compensate length by instrument over panel.
- **Intellectual Control**: Use intellectual software to monitor and control operation.

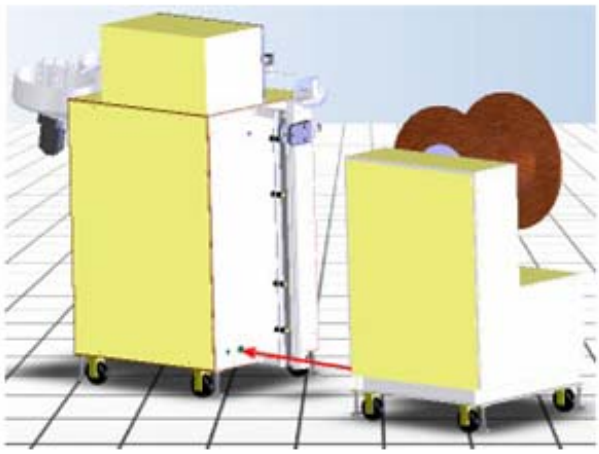
3. Main Technique Specification:

- **L x W x H = 2.1 x 0.8 x 1.1**
- **Weight**: 150Kg
- Voltage: 220VAC
- **Power**: 500W
- **Feed Speed**: 0.8 m/s
- **Length Accuracy**: 0.2%
- **Length Unit**: Meter
- **Length resolution: 0.01m**
- **Max Length: 9999m**
- **Cable Specification**: DIA 0.9-7.2mm

4. Before Operation

4.1. Connection btw main frame and cable-unwinding frame.

Plug cable-unwinding frame's cable into the socket over main frame. (refer to red arrow at below figure)



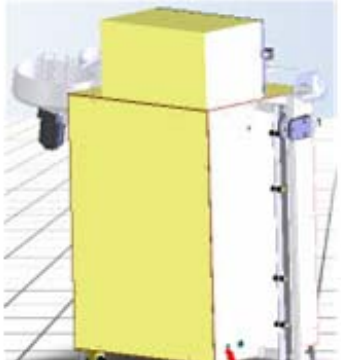
4.2. Air Source

Plug air tube into the valve aside main frame. Tube's diameter is 8 mm. (refer to blue table at below figure)

Rotate knob over the valve, adjust pressure till stable value of air gauge.

4.3. Power Source

Connect power cable into 220VAC power socket at workshop. (Refer to red arrow at below figure)



4.4. Open Power Switch

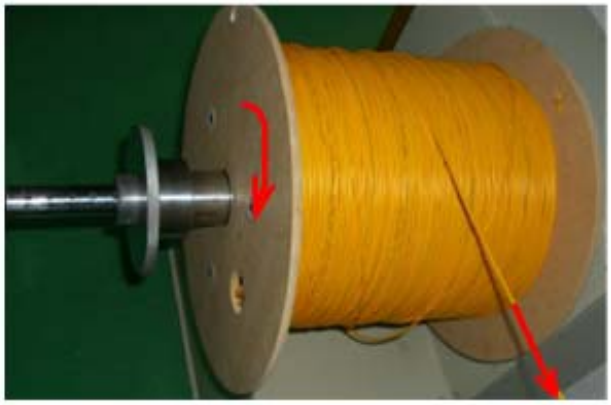
Switch on POWER button. POWER INDICATOR lights up.

Attention: Assure Speed Adjustor's buttons at ON position over main frame light side (refer to red arrow at below figure).

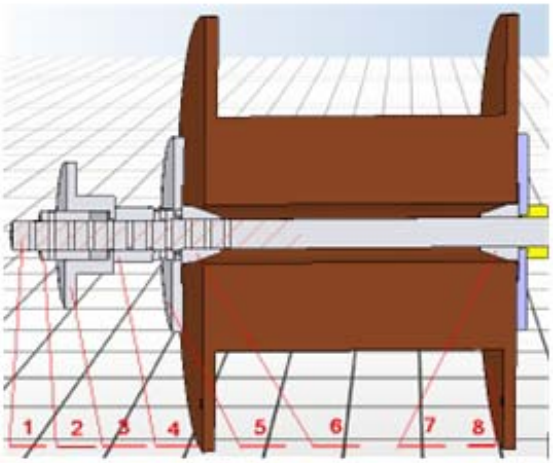
5. Load

5.1. Load Cable Wheel

Cable unwinding direction shows as red font at below figure.



Section view of cable wheel fixed at winding shaft assembly.



When Cable Wheel (#8) is fixed at Winding Shaft (#1), rotate the wheel (#5) to tighten Cable Wheel (#8). Refer to below figure. Red arrow shows CW direction to tighten Cable Wheel (#8), and CCW direction to release and loosen Cable Wheel (#8).

5.2. Tensional Wheel

Wrap cable to Tensional Wheel as figure below:

For harder cable (such as DIA 3 double cord cable), reduce wrapping circles to smooth slider up/down of Tensional Wheel.

5.3. Feed Cable

Click button ‘backward’ less than 0.5s, Feed Wheel will rise up, then feed cable till cable tip under Feed Wheel. Click button ‘backward’ less than 0.5s again, Feed Wheel will push down, snap cable and be ready for auto feeding.

Attention: Rotate the valve's knob (refer to red circle at below figure) to adjust Feed Wheel's pushing down force.

6. Parameter setup

6.1. Length

(Normal Panel)

(Press SET once into Length Setting)

(Press Digit Key to set Length)

(Press SET consecutively, set compensation)

Then Press SET key again, Metal will back to normal panel display.

6.2. Setup Qty

(Press Number Switch to setup qty)

7. Start

7.1. Press START button

Click START button, start auto running.
Attention: Click START button during running, machine will pause running till button clicked again.

7.2. Unload cable

(Take circle cable out of winding bowl)

Attention: Rotate Speed Adjustor's knob to adjust winding speed, be able to adjust winding diameter and tension. (show as below figure)

7.3. Auto-stop

When the cable quantity reaches preset value, the machine will stop automatically.

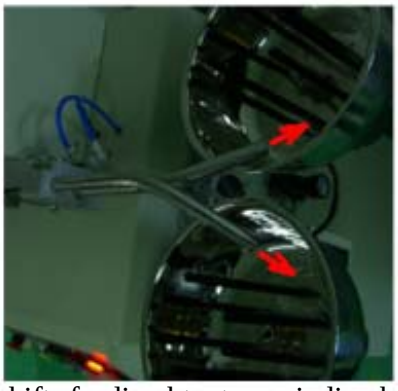
8. Manual Operation

8.1. Emergency Stop:

Whenever emergency occasion, press Emergency Stop button quickly, machine will shut down immediately.

Rotate mushroom shape head a little bit to uncover Emergency Stop button from stop status.

8.2. Manual Shift of Cable feeding



(Cable shifts feeding btw two winding bowls.)

(Unscrew butterfly screw to open cover)

Press button ‘backward’ more than 0.5s, the guider block will shift position btw up & down.

(Guider at Up Position)

(Guider at Down Position)

8.3. Tensional Stop

When cable btw two frames are too tight as the Tensional Sliding Wheel rises to up limit, the Up Limit Sensor will sense status and emergency stop the machine. Unloosen cable to let Tensional Wheel down, machine will re-start running again.

9. Maintenance

9.1. Change FUSE

9.2. Clean Cable Crapes

(Unscrew to open block…)

(Clear tunnel for cable feeding)

9.3. Adjust Tubes

(Unscrew to loosen tube, adjust tube's direction, screw to tighten tubes then)

9.4. Lubrication

Lubricate knife sliders at red arrow below.